



Dart Aerospace Ltd.
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D3049-1

Job Sheet 214180



Part No: D3049-1

Job Qty: 6 pcs

Part Name: Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/20/20

Job Tracking No:

Due Date: 11/3/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	4 pcs		10/31/20	0.17	1.19	Waterjet - Flow		on 20/12/11
120	HAAS 4 Axis - B4B	4 pcs		11/3/20	1.00	19.32	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 2	4 pcs		11/3/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
140	QC 8	4 pcs	11/3/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
170	Packaging 3-1 - Stock - B4B	4 pcs	11/3/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B

m/20/12/19

6 pcs
m/20DAS
289-89
DEC 21 2020

ST465

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180	QC 21 - SA	4 pcs	11/3/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 9
					QC 21 - SA - 77
					QC 21 - SA - 28

DAS 21 DEC 2 1 2020 465
9.89

Part Op 110 - CUT BLANK AS PER FILE D3049-1_BLANK
 Descriptions: 120 - (HAAS CNC Vertical Machine)1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA165 and Dwg D3049Identify as D3049-1
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - (QC8- Inspect parts - second check)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	13.6000 sf (3.4 ea)	110-Waterjet - Flow - 1	S262128

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	MUHMWB10	14	467	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.260Inches + 0.005 - 0.000	0.265 0.260	Diameter	0.260
2	Bearpaw	0.930Inches ± 0.030	0.960 0.900		0.930
3	Bearpaw	0.400Inches + 0.030 - 0.000	0.430 0.400		0.410
4	Bearpaw	2.000Inches ± 0.030	2.030 1.970		2.000
5	Bearpaw	10.310Inches ± 0.010	10.320 10.300		10.31
6	Bearpaw	2.870Inches ± 0.030	2.900 2.840		2.870
7	Bearpaw	8.000Inches ± 0.030	8.030 7.970		8.000
8	Bearpaw	0.380Inches ± 0.030	0.410 0.350		0.380
9	Bearpaw	11.500Inches ± 0.030	11.530 11.470		11.500
10	Bearpaw	0.070Inches ± 0.030	0.100 0.040		0.060
11	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	Angle	45°
12	Bearpaw	0.440Inches + 0.030 - 0.000	0.470 0.440		0.460
13	Bearpaw	0.250Inches ± 0.030	0.280 0.220	Radius	0.250
14	Bearpaw	0.950Inches + 0.030 - 0.010	0.980 0.940		0.965
15	Bearpaw	0.690Inches ± 0.030	0.720 0.660		0.710
16	Bearpaw	0.200Inches ± 0.030	0.230 0.170		0.200
17	Bearpaw	0.250Inches ± 0.030	0.280 0.220	Radius	0.250
18	Bearpaw	0.250Inches ± 0.030	0.280 0.220		0.250
19	Bearpaw	45.000Degrees ± 0.030	45.030 44.970	Angle	45°

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



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Container No: S320324



Part: D3049-1

Job No: 214180

Serial No/Batch: S320324

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/11/20